

Date: Monday, 11/08/2008 10:20:28 AM  
User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SEAT BACK (AFT FACING LH/RH)
<b>Job Number</b> : 41085	
<b>Estimate Number</b> : 13363	
<b>P.O. Number</b> :	<b>Part Number</b> : D37743
<b>This Issue</b> : 11/08/2008 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3774 REV <i>AB</i>
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : 11/08/2008 <b>Type</b> : THERMOFORMING	<b>Drawing Revision</b> : <i>XB</i> <i>Wh. 08.11</i>
<b>Previous Run</b> : 40868	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 28/08/2008 <b>Qty:</b> <i>11</i> <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>JUD 08.8.11</i>	
<b>Comment</b> : Est. REV:A New Issue 08.06.04 DL verified by:DD	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	HAND FINISH TH	HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

Set up machine program D3774-3  
Set up clamping frame as per folio

*BB 08/08/14*

2.0	MLEXS125F6002904	GE PLASTICS LEXAN SHEET
-----	------------------	-------------------------



Comment: Qty.: 10.6670 sf(s)/Unit Total: 106.6700 sf(s)

GE PLASTICS LEXAN SHEET

batch: *M105 330*

*BB 08/08/14 X 11*  
*BB 08/08/14*

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
-----	----------------	------------------------------



Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks

*BB 08/08/14 X 10*  
*BB 08/08/14 X 10*

4.0	THERMOFORMING	THERMOFORMING MACHINE
-----	---------------	-----------------------



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D32811 and Folio FTA 011

Dwg. Rev. *B*

Folio Rev. \_\_\_\_\_

*BB 08/08/15 X 11*  
*BB 08/08/15 X 10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
			DEC 2014					

**NOTE:** Date & initial all entries

Date: Monday, 11/08/2008 10:20:28 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT BACK (AFT FACING LH/RH)

Job Number: 41085

Part Number: D37743

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BB 08/08/27 X 11

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 08/08/27 X 11

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT TRIMMED PARTS

1) Check dimensions to ensure conformity to drawing tolerances.

BB 08/08/28 X 11

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/28 (X 11)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



ST249



Comment: PACKAGING RESOURCE #1

8/8/27

S (X)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/04

Job Completion



MF 08-09-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD	Work Order: 41085
Description: SEAT BACK (AET FACING)	Part Number: 037743
Inspection Dwg: 03774 Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype #1

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>          </u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 08/08/26

### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	± 0.100	1.31	✓			
1.9"	± 0.100	1.99	✓			
33.9"	± 0.100	33.9	✓			
0.065"	MIN	.080	✓			
0.085"	MIN	.130	✓			
0.100"	MIN	.134	✓			
0.100"	MIN	.131	✓			
0.100"	MIN	.125	✓			
0.100"	MIN	.142	✓			
0.100"	MIN	.119	✓			
0.100"	MIN	.137	✓			
0.100"	MIN	.118	✓			

Measured by: BB

Date: 08/08/26

Audited by:                     

Date: 08/08/26

Prototype Approval:                     

Date:                     

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	<u>                    </u>

DART AEROSPACE LTD	Work Order:	41085
Description: SEAT BACK (AFT FACING)	Part Number:	037743
Inspection Dwg: 03774 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#2

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>1.3"</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 08/08/28

### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	± 0.100	1.305	✓			
1.9"	± 0.100	1.908	✓			
33.9"	± 0.100	33.9	✓			
0.065"	MIN	.079	✓			
0.085"	MIN	.098	✓			
0.100"	MIN	.120	✓			
0.100"	MIN	.132	✓			
0.100"	MIN	.127	✓			
0.100"	MIN	.133	✓			
0.100"	MIN	.125	✓			
0.100"	MIN	.143	✓			
0.100"	MIN	.116	✓			

Measured by: BB

Date: 08/08/28

Audited by: S

Date: 08/08/28

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

DART AEROSPACE LTD	Work Order:	41085
Description: SEAT BACK (AFT FACING)	Part Number:	037743
Inspection Dwg: 03774 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#3

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>1.3"</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 08/08/27

### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	± 0.100	1.36	✓			
1.9"	± 0.100	1.93	✓			
33.9"	± 0.100	33.82	✓			
0.065"	MIN	.76	✓			
0.085"	MIN	104	✓			
0.100"	MIN	131	✓			
0.100"	MIN	148	✓			
0.100"	MIN	136	✓			
0.100"	MIN	172	✓			
0.100"	MIN	132	✓			
0.100"	MIN	156	✓			
0.100"	MIN	137	✓			

Measured by: BB

Date: 08/08/27

Audited by: S

Date: 8/6/28

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

DART AEROSPACE LTD	Work Order:	41085
Description: SEAT BACK (AFT FACING)	Part Number:	D37743
Inspection Dwg: D3774 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype #4.

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>1.3"</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB Date: 08/08/28

### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	± 0.100	1.31	✓			
1.9"	± 0.100	1.96	✓			
33.9"	± 0.100	33.95	✓			
0.065"	MIN	.086	✓			
0.085"	MIN	.100	✓			
0.100"	MIN	.135	✓			
0.100"	MIN	.168	✓			
0.100"	MIN	.140	✓			
0.100"	MIN	.142	✓			
0.100"	MIN	.133	✓			
0.100"	MIN	.152	✓			
0.100"	MIN	.141	✓			

Measured by: BB Date: 08/08/28

Audited by: S Date: 8/6/28

Prototype Approval:  Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



DART AEROSPACE LTD	Work Order: 41085
Description: SEAT BACK (AFT FACING)	Part Number: 037743
Inspection Dwg: 03774 Rev: 13	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#5

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 1.3"				
Shape Definition				
Texture Retention				
Material imperfections such as bumps, cracks, voids, scratching				

Measured by: BB

Date: 08/08/28

### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	+/- 0.100	1.26	✓			
1.9"	+/- 0.100	1.91	✓			
33.9"	+/- 0.100	33.98	✓			
0.065"	MIN	.73	✓			
0.085"	MIN	.96	✓			
0.100"	MIN	117	✓			
0.100"	MIN	168	✓			
0.100"	MIN	149	✓			
0.100"	MIN	120	✓			
0.100"	MIN	126	✓			
0.100"	MIN	140	✓			
0.100"	MIN	114	✓			

Measured by: BB

Date: 08/08/28

Audited by: C

Date: 8/6/28

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

DART AEROSPACE LTD	Work Order: 41085
Description: SEAT BACK (AFT FACING)	Part Number: 037743
Inspection Dwg: 03774 Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>2"</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching				

Measured by: BB

Date: 08/08/28

### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	± 0.100	1.32	✓			
1.9"	± 0.100	1.96	✓			
33.9"	± 0.100	33.95	✓			
0.065"	MIN	074	✓			
0.085"	MIN	099	✓			
0.100"	MIN	114	✓			
0.100"	MIN	135	✓			
0.100"	MIN	128	✓			
0.100"	MIN	128	✓			
0.100"	MIN	121	✓			
0.100"	MIN	142	✓			
0.100"	MIN	138	✓			

Measured by: BB

Date: 08/08/28

Audited by: S

Date: 8/6/28

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

DART AEROSPACE LTD	Work Order:	41085
Description: SEAT BACK (AFT FACING)	Part Number:	D37743
Inspection Dwg: D3774 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#7

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>1.3"</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 08/08/28

### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	± 0.100	1.294	✓			
1.9"	± 0.100	1.86	✓			
33.9"	± 0.100	33.98	✓			
0.065"	MIN	.071	✓			
0.085"	MIN	.092	✓			
0.100"	MIN	108	✓			
0.100"	MIN	133	✓			
0.100"	MIN	118	✓			
0.100"	MIN	119	✓			
0.100"	MIN	119	✓			
0.100"	MIN	124	✓			
0.100"	MIN	109	✓			

Measured by: BB

Date: 08/08/28

Audited by: S

Date: 8/8/28

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

DART AEROSPACE LTD	Work Order:	41085
Description: SEAT BACK (AFT FACING)	Part Number:	037743
Inspection Dwg: 03774 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

#8

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>1.3"</u>				
Shape Definition	BB			
Texture Retention	BB			
Material imperfections such as bumps, cracks, voids, scratching	BB			

Measured by: BB

Date: 08/08/27

### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	$\pm 0.100$	1.28	✓			
1.9"	$\pm 0.100$	1.96	✓			
33.9"	$\pm 0.100$	33.92	✓			
0.065"	MIN	.068	✓			
0.085"	MIN	.094	✓			
0.100"	MIN	.129	✓			
0.100"	MIN	.173	✓			
0.100"	MIN	.136	✓			
0.100"	MIN	.129	✓			
0.100"	MIN	.126	✓			
0.100"	MIN	.155	✓			
0.100"	MIN	.134	✓			

Measured by: BB

Date: 08/08/27

Audited by:

Date: 8/6/28

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

DART AEROSPACE LTD	Work Order: 41085
Description: SEAT BACK (AFT FACING)	Part Number: 037743
Inspection Dwg: 03774 Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype #9

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 1/2"				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 08/08/28

### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	± 0.100	1.31	✓			
1.9"	± 0.100	1.928	✓			
33.9"	± 0.100	33.95	✓			
0.065"	MIN	.075	✓			
0.085"	MIN	.095	✓			
0.100"	MIN	.123	✓			
0.100"	MIN	.149	✓			
0.100"	MIN	.150	✓			
0.100"	MIN	.172	✓			
0.100"	MIN	.127	✓			
0.100"	MIN	.159	✓			
0.100"	MIN	.135	✓			

Measured by: BB

Date: 08/08/28

Audited by: 8

Date: 8/8/28

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

DART AEROSPACE LTD	Work Order: 41085
Description: SEAT BACK (AFT FACING)	Part Number: D37743
Inspection Dwg: D3774 Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype #10

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>1.3"</u>				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB Date: 08/08/28

### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	± 0.100	1.31	✓			
1.9"	± 0.100	1.93	✓			
33.9"	± 0.100	33.97	✓			
0.065"	MIN	.072	✓			
0.085"	MIN	.100	✓			
0.100"	MIN	.137	✓			
0.100"	MIN	.144	✓			
0.100"	MIN	.129	✓			
0.100"	MIN	.150	✓			
0.100"	MIN	.180	✓			
0.100"	MIN	.160	✓			
0.100"	MIN	.140	✓			

Measured by: BB Date: 08/08/28  
Audited by: S Date: 08/08/28  
Prototype Approval:  Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	

DART AEROSPACE LTD	Work Order: 41085
Description: SEAT BACK (AFT FACING)	Part Number: 037743
Inspection Dwg: 03774 Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype 11

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 1"				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB Date: 08/08/28

### TRIMMING SECTION

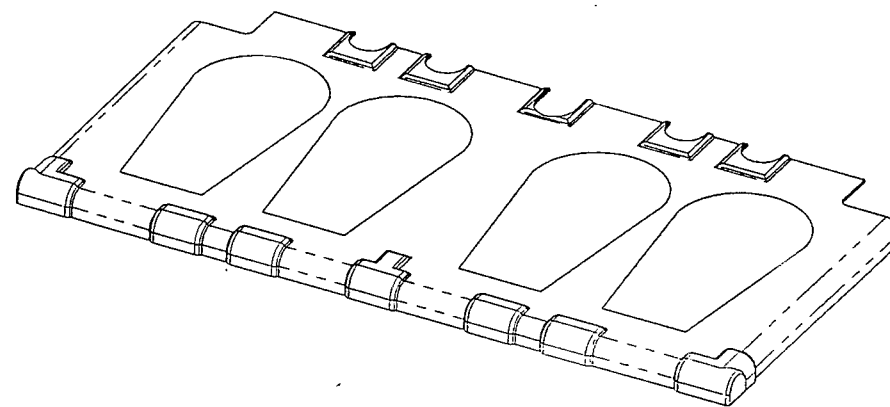
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.3"	± 0.100	1.30	✓			
1.9"	± 0.100	1.98	✓			
33.9"	± 0.100	33.98	✓			
0.065"	MIN	.074	✓			
0.085"	MIN	.095	✓			
0.100"	MIN	.122	✓			
0.100"	MIN	.174	✓			
0.100"	MIN	.163	✓			
0.100"	MIN	.157	✓			
0.100"	MIN	.127	✓			
0.100"	MIN	.153	✓			
0.100"	MIN	.133	✓			

Measured by: BB Date: 08/08/28

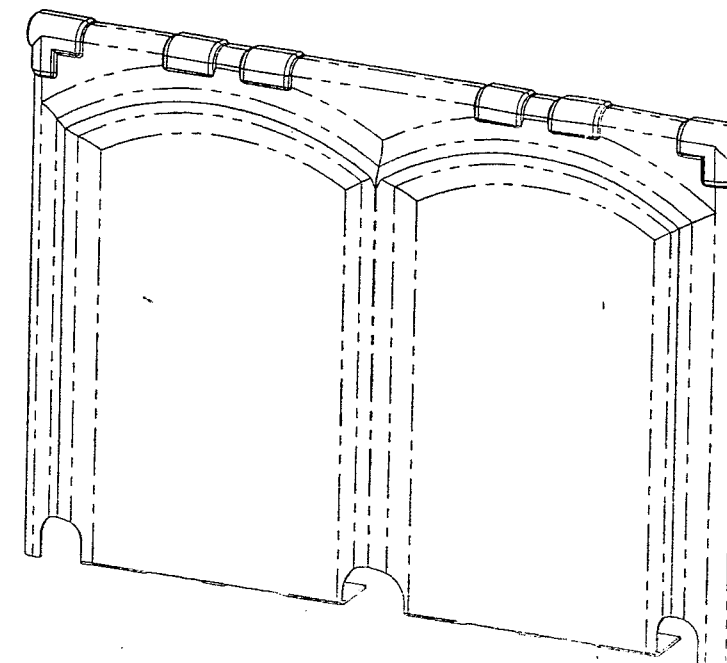
Audited by: S Date: 08/08/28

Prototype Approval: Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



D3774-1 SEAT BOTTOM



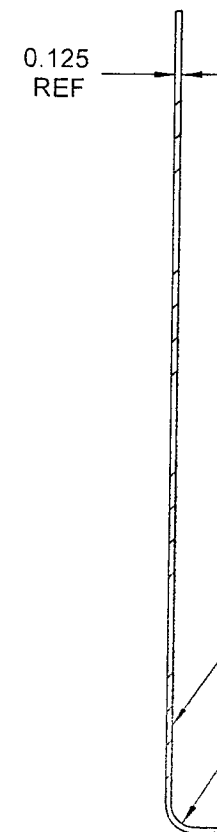
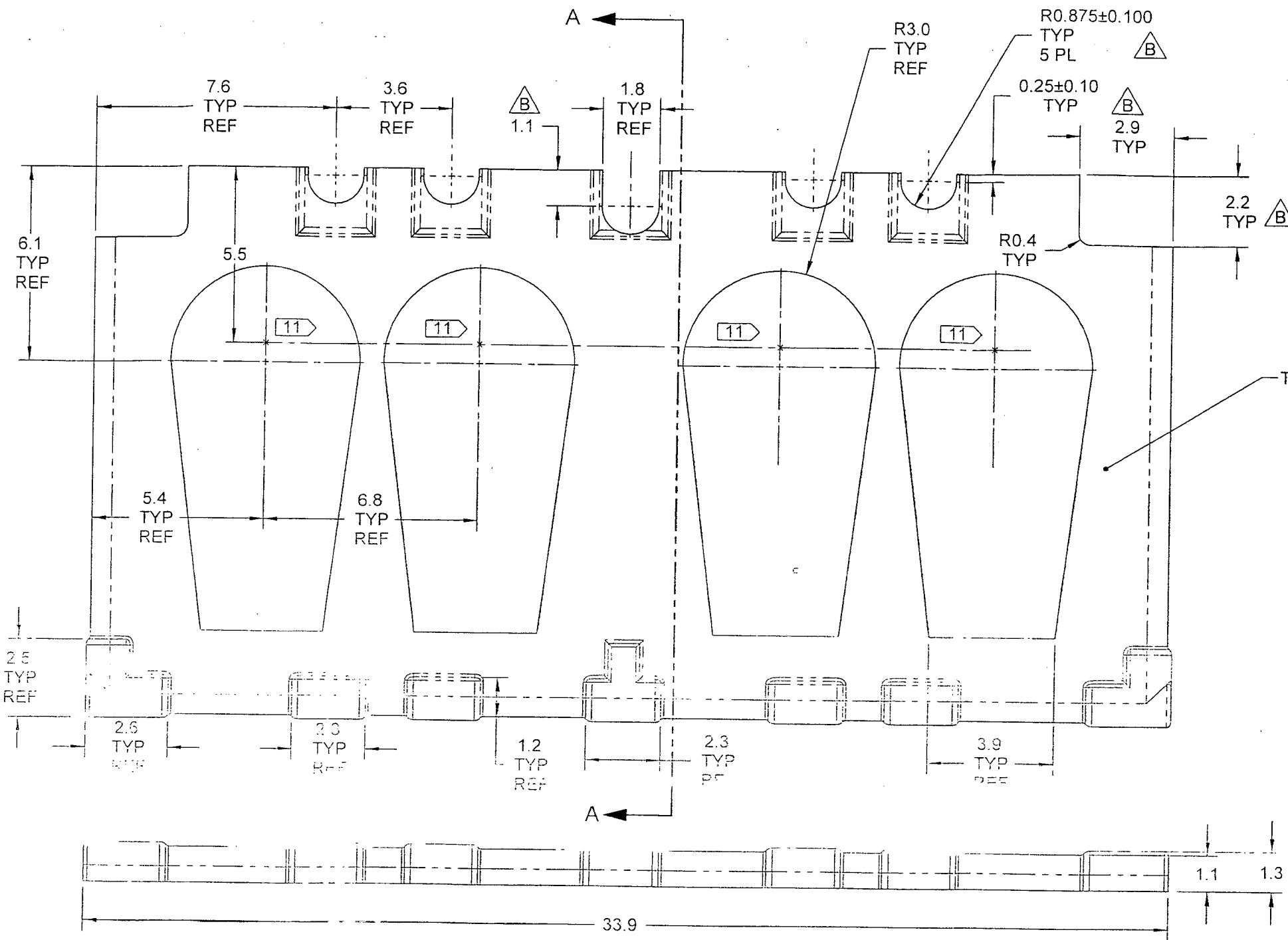
D3774-3 SEAT BACK

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 41085

**RELEASED**  
08-08-11/11

B	UPDATE CUTOUT DIMENSIONS (ZN D4-2, D6-2, C4-3, C7-3); UPDATE MINIMUM THICKNESS (ZN A5-2, A5-3); ADD HOLES ON D3774-3 (ZN B6-3) REASON: MANUFACTURING CAPABILITIES		PH	08.07.25
A	NEW ISSUE		HS	08.06.23
REV.	DESCRIPTION		BY	DATE
DESIGN	HS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	PH			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3774	SHEET 1 OF 3	
APPROVED		TITLE	SCALE	
DE APPR.		SEAT	NTS	
DATE	08.07.25		COPY RIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	





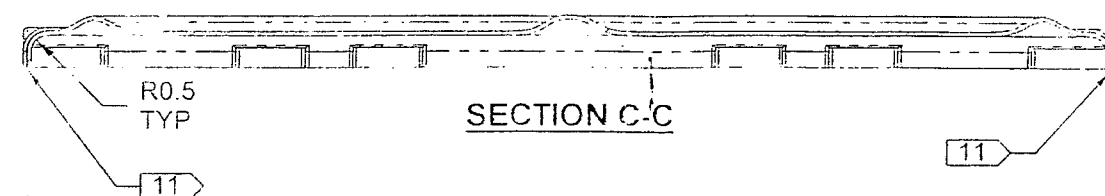
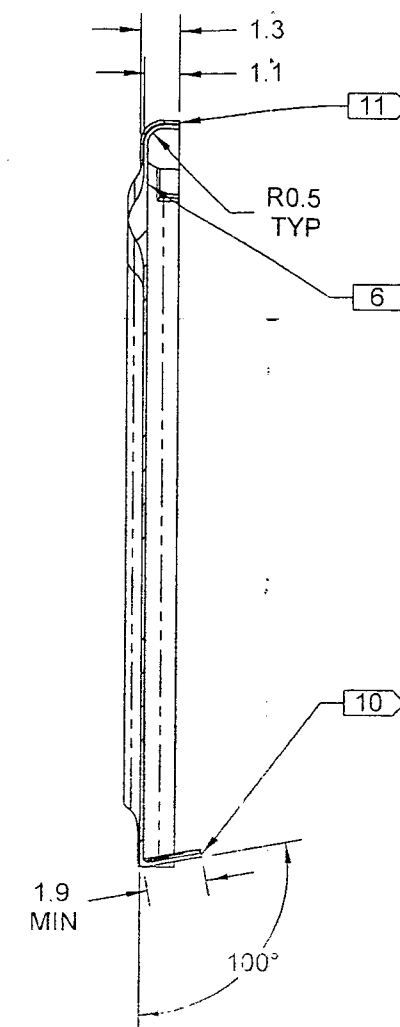
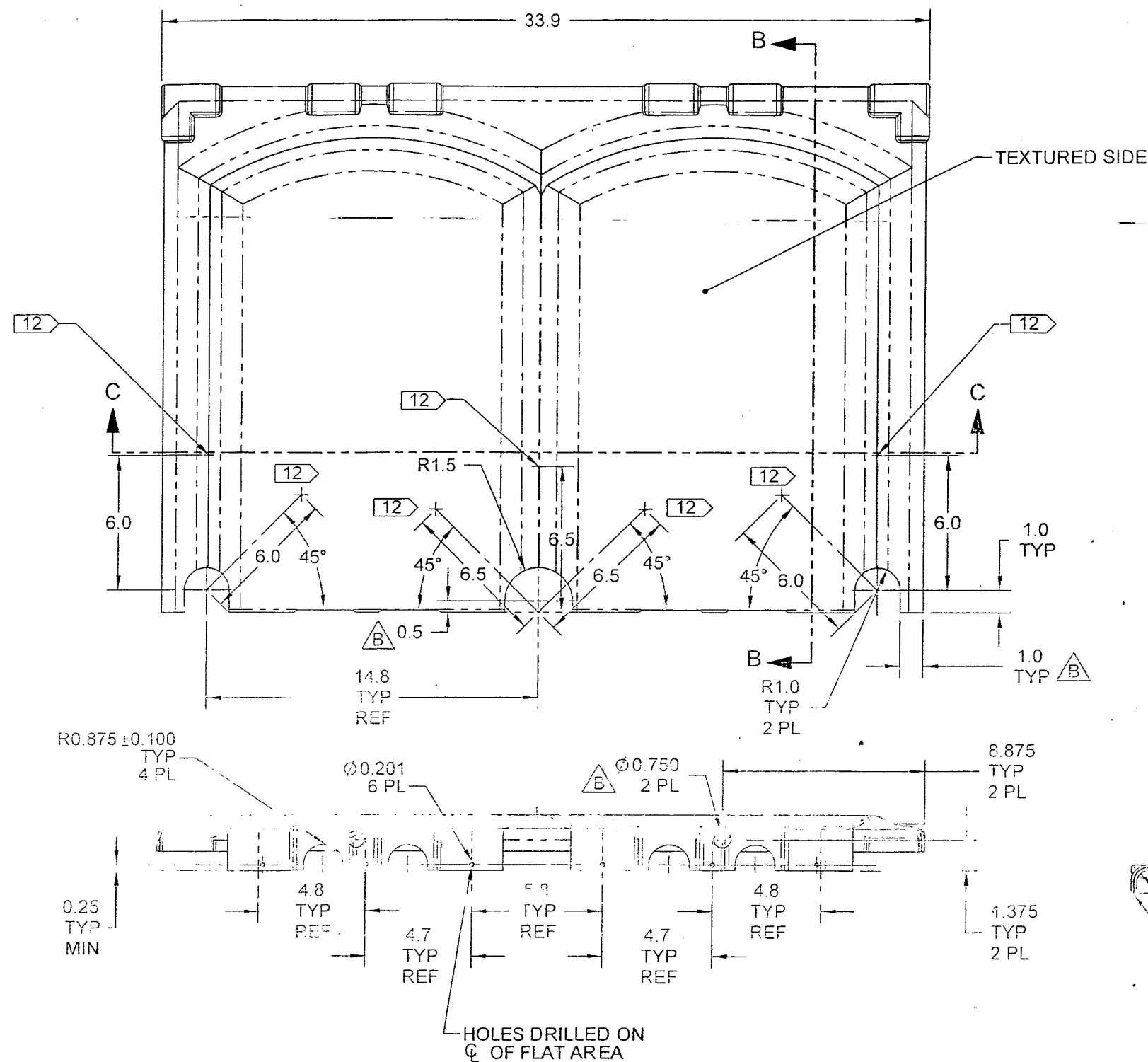
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 41085

# **D3774-1 SEAT BOTTOM**

- NOTES:
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS.125-F60029-04)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-1" USING VIBRATING STYLUS
  - 7) WEIGHT: 2.93 lbs
  - 8) PART TO BE PRODUCED FROM MOLD DT9022 AND PER DART QSI 022
  - 9) OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9022
  - 10) MINIMUM MATERIAL THICKNESS AFTER FORMING ON FLANGES (WITHIN 2.0 FROM EDGES) IS 0.085
  - 11) MINIMUM MATERIAL THICKNESS AFTER FORMING AT THESE POINTS IS 0.100

**RELEASED**  
08-08-11

DESIGN	HS	<b>DART AEROSPACE LTD</b>	
DRAWN	PA	HAWKESBURY, ONTARIO, CANADA	
CHECKED	h	DRAWING NO.	REV. E
MFG. APPR.	h	D3774	SHEET 2 OF 3
APPROVED	h	TITLE	SCALE
DE APPR.	h	SEAT	NTS
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WORK ORDER  
NO. 41085

# D3774-3 SEAT BACK

- NOTES:
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS.125-F60029-04)
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-3" USING VIBRATING STYLUS
  - 7) WEIGHT: 4.82 lbs
  - 8) PART TO BE PRODUCED FROM MOLD DT9023 AND PER DART QSI 022
  - 9) OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9023
  - 10) MINIMUM MATERIAL THICKNESS AFTER FORMING ON BOTTOM FLANGE IS 0.065
  - 11) MINIMUM MATERIAL THICKNESS AFTER FORMING FLANGES (WITHIN 2.0 FROM EDGES) IS 0.085
  - 12) MINIMUM MATERIAL THICKNESS AFTER FORMING AT THESE POINTS IS 0.100

RELEASED  
08-05-11

DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PSA		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3774	SHEET 3 OF 3
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DE APPR.		SEAT	NTS
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